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20NR-119-9-DHC
Job Sheet 191245



Part No: 20NR-119-9-DHC

Job Qty: 1 pcs

Part Name: Guard



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 5/10/19 April 20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 20NR-119-9-DHC Rev.2 IPP Rev. A 19.02.11 New issue DP Verify DD

Ship Via:

Bill of Materials



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Container No: S173554



Part: 20NR-119-9-DHC

Job No: 191245

Serial No/Batch: S173554

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 04/18/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	5/10/19		0.00	1.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 5	4 pcs	5/10/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Packaging 3-1 - Stock - B4B	4 pcs	5/10/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	4 pcs	5/10/19		0.00	0.00	QC 21 - SA - 21		
							QC 21 - SA - 70		
							QC 21 - SA - 53		

Part Op
Descriptions: 100 - Fabricate as per drawing.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018TR1.00W.095	M1018TR1.00W.095	19.2000 ft (4.8 ea)	100-Large Fab - Welded Assy-1	
MT-A513-T-1.000W0120			5169079	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	M1018TR1.00W.095	19	0	0

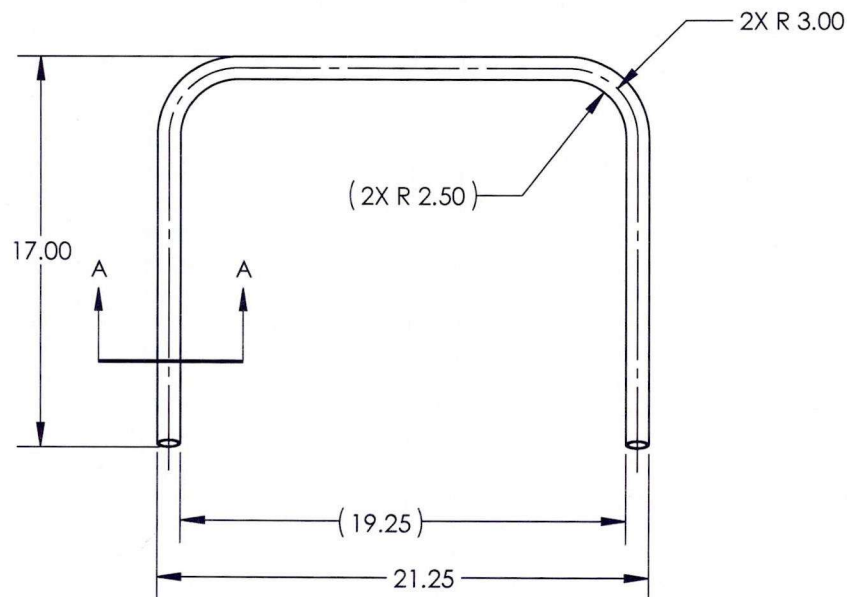
Part Specifications

Specifications could not be found.

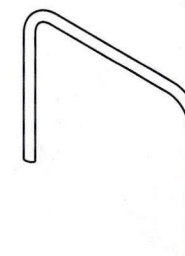
Plex 2/25/19 10:49 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CH'D INSIDE RADIUS WAS 2X R5.13 IS 2X R3.00. ADDED DIM 21.25 AND CH'D DIM WAS 18.50 IS (19.25).	6/18/2014	RJC	JAG
2	15-0357	UPDATED TO NEW DRAFTING STANDARDS. CH'D DIMS WAS (2X R3.50) IS 2X R3.00, WAS 2X R3.00 IS (2X R2.50), WAS (Ø1.00) IS Ø1.00, WAS (Ø.81) IS Ø.81, WAS 2X 18° IS 2X 18°±2°. DELETED DIM 16.00. ADDED DIM 17.00.	11/13/2015	DPD	JAG



2X 18°±2°



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191245 MJS
19-02-25



SECTION A-A
SCALE 1 : 2

USED ON
20NR-DHC
8NR-DHC

DART AEROSPACE	
TITLE GUARD	
DWG NO. 20NR-119-9-DHC	REV 2
MAT'L 1018/1026 CDS	DRAWN BY: SMITH
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .010 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .03 ANGLES ±1°	FINISH SEE WELDMENT
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:8	DATE 10/8/2013 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			20NR-119-9-DHC	1	GUARD	1018/1026 CDS	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					